

Date: Tuesday, 4/17/2007 11:05:07 AM
User: Kim Johnston

Process Sheet

split
80 07/07/04

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 31833		
Estimate Number	: 11119		
P.O. Number	: <i>N/A</i>	Part Number	: D30411
This Issue	: 4/17/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3041 REV.C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 26217	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/24/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>50</i> Um: Each
Comment	: Est A 01.07.11 New Issue SM est B 07.04.09 rev.c dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0875 f(s)/Unit Total 3.4986 f(s)

Lug Extrusion

(D2423)

Batch:

*330662 En**07/04/27**(X50)*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

*En**07/04/27**(X50)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

*Issue P.O. 3663**Machine per drawing D3041 Rev C**07/04/30**(50)*

4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE
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RG*Receive + inspect for transit damage*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

inspect level

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

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Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FK 07/05/14

(50)

7.0 QC5 INSPECT WORK TO CURRENT STEP



(50x)

Comment: INSPECT WORK TO CURRENT STEP

M.L. 07/05/15

8.0 POWDER COATING POWDER COATING



(60x)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Mask inside of 0.8120" diameter hole

M.L. 07/05/16

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(50)

Comment: INSPECT POWDER COAT

FK

07/05/17

(50)

10.0 D2611 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
Bearing
Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	B30914 (20)

B31888 (30)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Press D2611 bearing into lug as per Dwg D3041
2- Stake bearing into place as per Dwg D3041

SB 07/07/04

12.0 QC5 INSPECT WORK TO CURRENT STEP



Counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/05

(40)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

07/07/09 (40)

Process Sheet

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Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

140

QC21

FINAL INSPECTION/W/O RELEASE



(40)

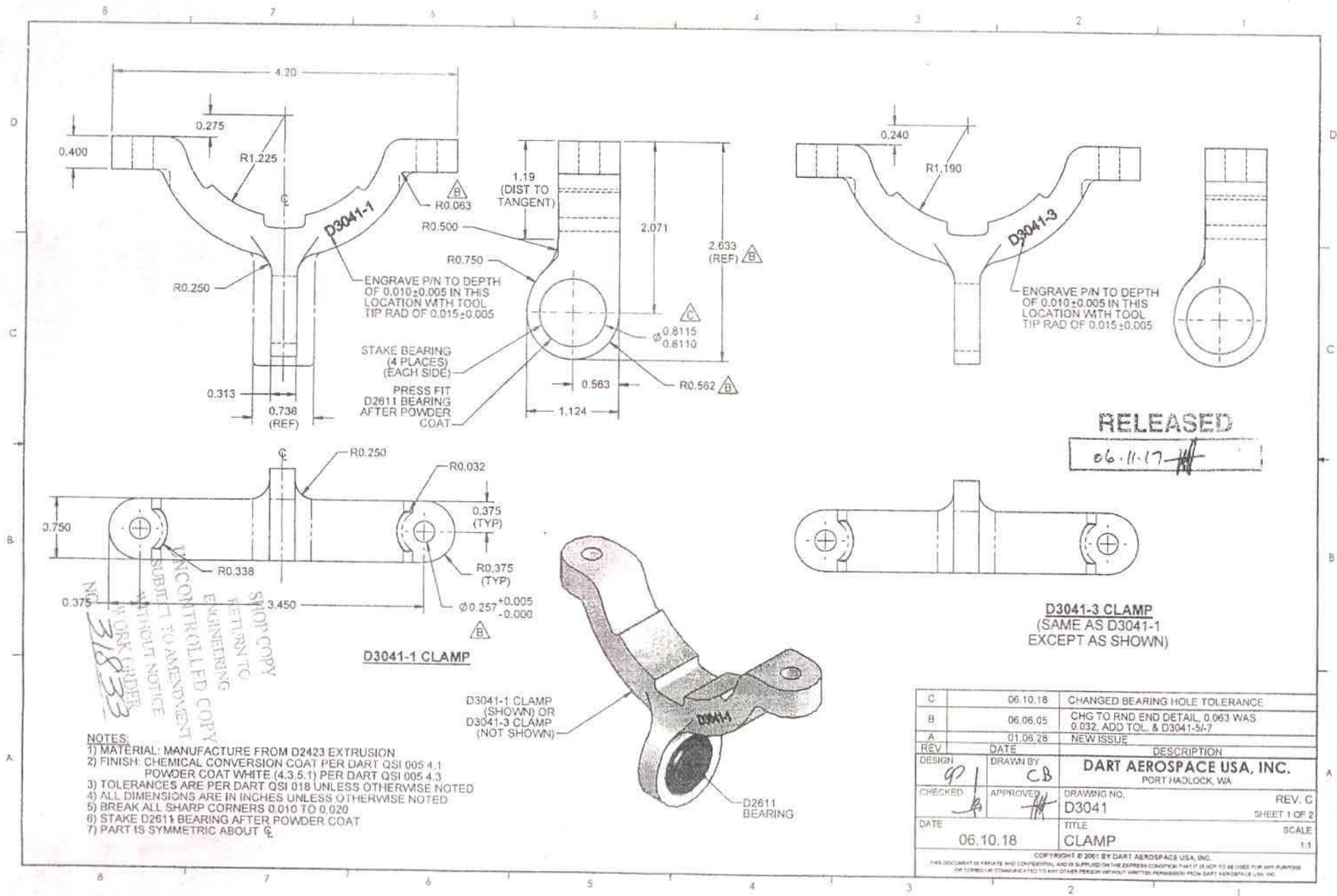
Comment: FINAL INSPECTION/W/O RELEASE

207/07/09

Job Completion



207/07/09



C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-3/-7
A	01.06.26	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
		REV. C SHEET 1 OF 2 SCALE 1:1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/04	11	Split w/o	S/S	07/07/04	39		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries